

# Work Order ID 65502

January 19, 2011 9:06:49 AM



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Item ID:	D4189-7	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Pin					
Start Date:	1/19/11	Start Qty: <sup>5</sup> 2.00		Cust Item ID:		
Required Date:	2/04/11	Req'd Qty: 2.00		Customer:		
Reference:						

Approvals:	Process Plan: <u>CL</u>	Date: <u>11/01/19</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D4189	PAT PA2 <u>11.01.28</u>								
100	PURCHASING	0.00							
	Purchasing								
Purchasing	Memo	0.00							
	Issue P/O: <u>13321</u>								
	Possible Supplier: MCMaster Carr								
	Material release note required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
	Packaging								
Packaging	Memo	0.00							
	Ensure material certification is attached								
120	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
Quality Control	Memo	0.00							
	<u>Inspector to PA2</u>								
	<u>Day only</u>								
	<u>8/10/12</u>								

CL 11/01/19 (5)

CL 1/24 (5)



CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 65502



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January 19, 2011 9:06:49 AM

Item ID:	D4189-7	Accept		Setup	Start	
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Start Date:	1/19/11	Start Qty: 2.00		Cust Item ID:		
Required Date:	2/04/11	Req'd Qty: 2.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Identify as per dwg & Stock Location: _____	0.00							
Packaging Packaging	Memo	0.00							
140 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

POSITIVE RECALL  
EFFECTIVE 11.01.20 AUTH u  
RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

PRELIMINARY ISSUE

*PL 11-069 (5) Eash*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

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January 19, 2011 9:06:49 AM

Work Order ID: 65502



Parent Item: D4189-7



Parent Item Name: Pin



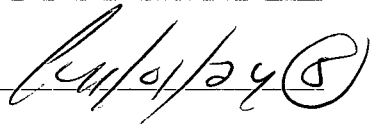
Start Date: 1/19/11

Required Date: 2/04/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV: A NEW ISSUE 11-01-19 VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
97395A453  Pin		Purchased			No		Each	0.0000		2			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

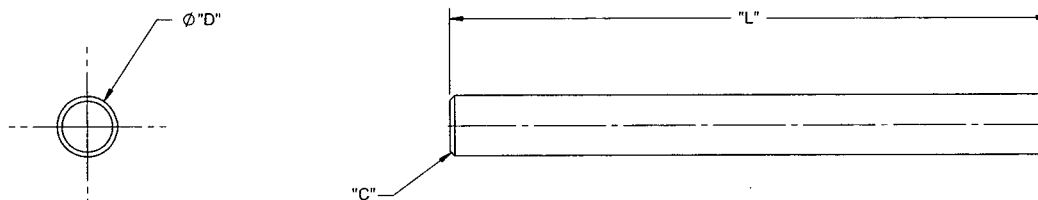
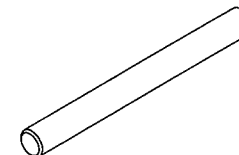
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# SPECIFICATION CONTROL DRAWING



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 65502  
CL 11/01/19

DART PART NUMBER	DESCRIPTION	SUPPLIER	SUPPLIER PART NUMBER	LENGTH "L"	DIAMETER "D"	CHAMFER "C"
D4189-7	PIN	McMASTER-CARR	97395A453	1.25	0.125	0.01 X 45°

D4189-X PIN

- NOTES:  
1) MATERIAL: SEE TABLE  
2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 0.004 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4189</b>	REV. PA2
MFG. APPR.	<i>[Signature]</i>		SHEET 5 OF 5
APPROVED		TITLE <b>PIVOT</b>	SCALE NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD	
DATE	<b>10.11.12</b>	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

\*\*\*PO REPRINT\*\*\*

Purchase Order ID PO13321

Purchase Order Date 1/19/11

PO Print Date 1/20/11

Page Number 1 of 2

Order From :

VU-MCM001

MCMaster-CARR SUPPLY CO,  
P.O. BOX 7690  
CHICAGO, IL 60680-7690  
US

Contact Name

Vendor Phone 330 995 5500

Vendor Fax 330 995 9600

Vendor Account Nbr

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

PR100128

10127-2607

Net 30

USD

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAXED**  
Call 1/20/11

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	97395A453	Pin	1/21/11 Yes	5.00 Each	Purolator ground	\$1.2260	\$6.13
Special Inst:			AS PER DWG D4189 REV. PA2 B65502 MCMaster P/N:				
2		90261A151 INSERT TOOL	1/21/11 Yes	1.00	Purolator ground	\$84.2700	\$84.27
3	Deliver To: SYLVIE	91709A101 TAP	1/21/11 Yes	3.00	Purolator ground	\$15.2100	\$45.63
4	Deliver To: SYLVIE	2522A816 5-44 TAP	1/21/11 Yes	3.00	Purolator ground	\$5.9800	\$17.94
Deliver To: SYLVIE							

1/20/11



200 Aurora Industrial Parkway  
Aurora OH 44202  
330-995-5500  
cle.sales@mcmaster.com

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawkesbury ON K6A 1K7  
Canada

Purchase Order  
PO13321

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McMaster-Carr Number  
2720636-01

01/20/2011

Line		Description	Ordered	Shipped	LNS A11	
1	97395A453	Type 316 Stainless Steel Dowel Pin, 1/8" Diameter, 1-1/4" Length, Packs of 5	1 Pack	1	2 - 691 - 06	26 - 16 A453 1 PK
		Unit Price: \$6.13				
		Extended Price: \$6.13				
2	90261A151	Helical Insert Installation Tool, 4-40 Internal Thread, Style A	1 Each	1	2 - 136	
		Unit Price: \$84.27				
		Extended Price: \$84.27				
3	91709A101	Helical Insert Tap, 4-40 Internal Thread, Plug Style	3 Each	3	2 - 136	
		Unit Price: \$15.21				
		Extended Price: \$45.63				
4	2522A816	General Purpose High-Speed Steel Hand Tap, Bottoming, 5-44, H2 Pitch Diameter, 3 Flute	3 Each	3	2 - 513	
		Unit Price: \$5.98				
		Extended Price: \$17.94				

Dart Aerospace Ltd

EXP

Sm  
12x7x5



1 lb  
6 lines

FW1WBP27  
01/20/2011  
09:49/10:02  
838  
Cycle 22

1102035617455

